

Date: Monday, 3/19/2007 4:36:37 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OH-58 STEP ASSY LH *UNDER REVIEW**
Job Number	: 31293		
Estimate Number	: 12438		
P.O. Number	: <i>N/A</i>	Part Number	: D058677011
This Issue	: 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2943 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: UNDER <i>REV-B</i>
Previous Run	: 30793	Material	: <i>N/A</i>
Written By	:	Due Date	: 4/6/2007
Checked & Approved By	: <i>[Signature] 07.03.20</i>	Qty:	5 Um: Each
Comment	: Est Rev:B 01.04.11 Combined with D2943-041 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD058-677-011	CHG 001	<i>KS 07.03.23</i> (5)
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2.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit	Total : 5.0000 Each(s)
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Extrusion D2622-120C

Batch: *B30199**FF 07-05-01*

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit	Total : 10.0000 Each(s)
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D2734 206 Step Endplate

Batch: *B27281 = 5* *329340 = 5**FF 07-05-01*

4.0	D2725	206 Step Lug
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Comment: Qty.: <i>2</i> 1.0000 Each(s)/Unit	Total: <i>10</i> 5.0000 Each(s)
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D2725 206 Step Lug

Batch: *B28972**FF 07-05-01*

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

A/R AL ROD

Batch: *M102756* *M103317**FF 07-05-01**FF 07-05-02**FF 07-05-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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# Process Sheet



Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH \*UNDER REVIEW\*\*

Job Number: 31293

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Grind end cap welds flush as per dwg D2943

*PE. 07-05-02 5*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/05/03 (5)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/05/03 (5)*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.L. 07/05/07*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FF 07-05-08 5*

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482  
A/R AL ROD Batch: *m/02756*

*PE. 07-05-09 5*

2-Grind end cap welds flush as per dwg D2943

*FF 07-05-09 5*

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/05/09 (5)*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/05/09 (5)*

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

*07-05-16 (5)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Job Number: 31293

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



M1 103706



5X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/05/16

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M103707

5X/22 07/05/16 (3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20705-17 (3)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20705-17 (3)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

19.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mounting Lug

Batch: 1327449 159112

X

20.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mounting Lug

1329710 ✓

21.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mounting Lug

Batch: 1322591

X

7/5/17 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number: 31293

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Mounting Lug

Batch: 1329339 ✓

23.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Batch: M102280 ✓

24.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Batch: M103947 ✓

25.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Batch: M102929 ✓

26.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nut

Batch: M103914 ✓

M102552 ✓

7/5/17 SQ

27.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/5/17 (5) (2071051178)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location:

PPP Rev: B

7/5/17 (5) SQ

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/05/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 31293

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

2065/17

Job Completion



2065/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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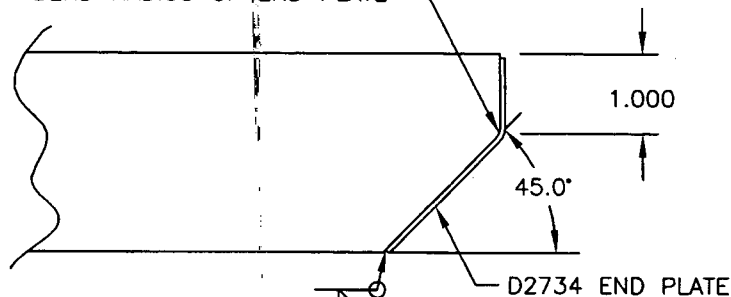
NOTE: Date & initial all entries

**DART**

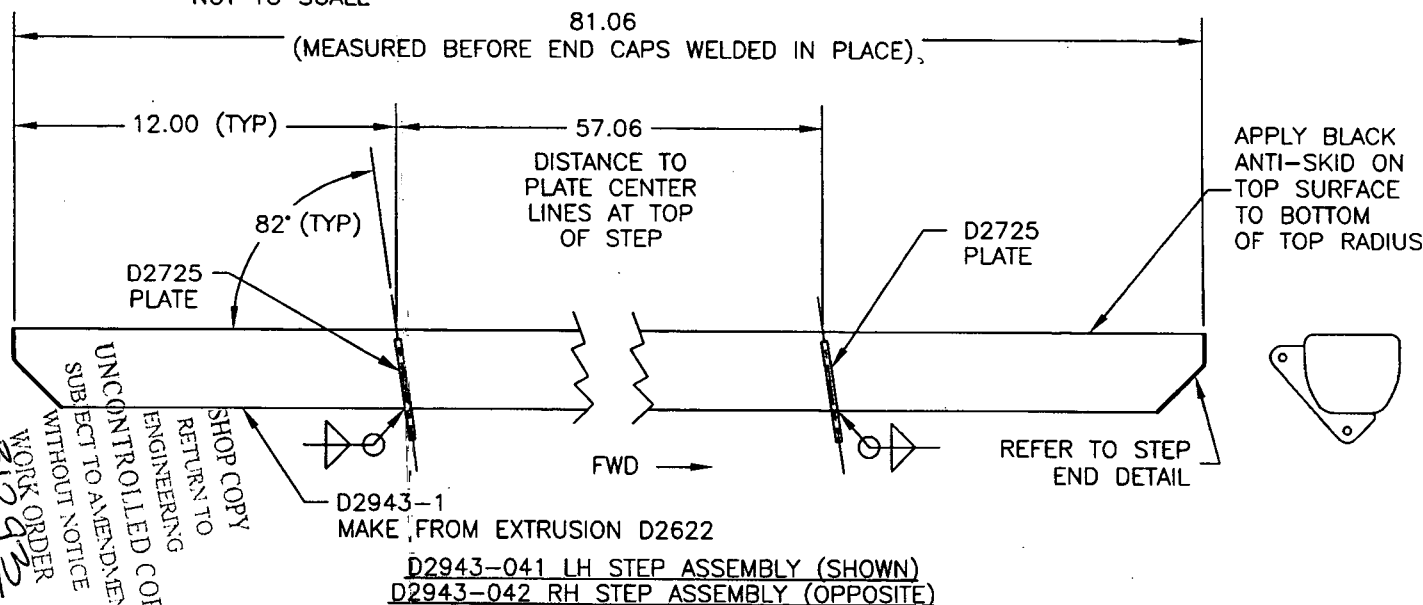
DESIGN	RF	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>
DATE	05.11.14	TITLE	OH-58 STEP ASSEMBLY
A	99.11.19	NEW ISSUE	
B	05.11.14	UPDATE FINISHING NOTE	
REV. B		SHEET 1 OF 1	
SCALE	NTS		

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE



**D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST**

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2943-041	LH STEP ASSEMBLY
	X	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

\*out per drawing

**D2943-041/-042 OH-58 STEP ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
05.11.28-110

**UNDER REVIEW**  
06.03.29  
RE-DESIGN  
COMPARE TO 2406-639